

**Work Order ID 72981**

Tuesday, August 23, 2011 8:29:11 AM

Ship Aug 31  
Page 1

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 8-08-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/2012

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

\*\*\*\*Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*\*

8/11/09/22 ①

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/8/2012

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72981**

Page 2

Tuesday, August 23, 2011 8:29:11 AM

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RR 72980

11/9/2011

11/9/2011

mf 11-09-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, August 23, 2011 8:29:16 AM



1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.




5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

[illegible]

**Required Date:** 8/29/2011

**Required Qty: 1.00**

**Comments:** IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232  Placard, Max Load		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST122				5					
				66274				1					
				72052				4					
D2530  Handle Weldment		Manufactured	No			100	Each	16.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				15					
				70850				5					
				72166				10					
				ST508				1					
				69318				1					
D2535  Spring		Manufactured	No			100	Each	95.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				95					
				71117				95					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 72981

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100 Each

39.0000

2

2



Bushing

Location

Loc Qty

Loc Code

ST504

39

71853

39

D3917-3

Manufactured No

100 Each

25.0000

6



Washer

Location

Loc Qty

Loc Code

ST092

25

69896

3

72142

22

D3953-3

Manufactured No

100 Each

0.0000

2

2



Gas Spring Stud, Lid

D3953-7

Manufactured No

100 Each

19.0000

2

2



Spring Spacer

Location

Loc Qty

Loc Code

ST096

19

65053

4

71885

15

D3953-9

Manufactured No

100 Each

22.0000

2

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST096

22

69025

4

71869

18

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Page 3

Work Order ID: 72981

Parent Item: D4032-041



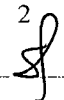
Parent Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011




Start Qty: 1.00

Required Qty: 1.00

D3953-17	Manufactured	No	100	Each	10.0000	2	2
							
Gas Spring Spacer							




<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST096	10	
<del>71870</del>	10	

D3953-19	Manufactured	No	100	Each	7.0000	1	1
							
Gas Spring Bracket							




<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST096	7	
59213	1	
<u>68462</u>	6	

D3953-21	Manufactured	No	100	Each	6.0000	1	1
							
Gas Spring Bracket							



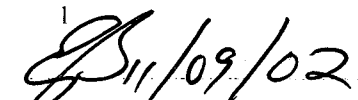
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST096	6	
68463	6	

D3969-3	Manufactured	No	100	Each	7.0000	1	1
							
Spring (Basket Lid)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST272	7	
64285	1	
<u>68925</u>	6	

D4017-041	Manufactured	No	100	Each	0.0000	1	1
							
Short Basket Base Assembly (350 )							

B72982 (100)

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, August 23, 2011 8:29:17 AM

Page 4

Work Order ID: 72981

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-041 Manufactured No

100 Each 0.0000 1



Short Basket Lid Assembly (350)

B72983 @

8/24/09/02

AN3-14A Purchased No

100 Each 88.0000 4



Bolt

Location

Loc Qty

Loc Code

ST352

88

117872

88

AN3-16A Purchased No

100 Each 181.0000 2



Bolt

Location

Loc Qty

Loc Code

ST352

181

117441

81

118628

100

AN4-12 Purchased No

100 Each 83.0000 3



Bolt

Location

Loc Qty

Loc Code

ST357

83

117514

33

118626

50

AN5-17A Purchased No

100 Each 84.0000 4



Bolt

Location

Loc Qty

Loc Code

ST337

40

118422

40

ST339

44

117872

44

Tuesday, August 23, 2011 8:29:17 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Tuesday, August 23, 2011 8:29:17 AM

Page 5

Work Order ID: 72981

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-4  
NUT

Purchased

No

100

Each

54.0000

3

3

Location

Loc Qty

Loc Code

ST324

54

118078

4

118112

50

AN310C4  
Nut

Purchased

No

100

Each

56.0000

2

Location

Loc Qty

Loc Code

ST324

56

116741

1

117395

25

118090

10

118626

20

MS21042L3  
Nut

Purchased

No

100

Each

1,857.000

6

Location

Loc Qty

Loc Code

ST300

1857

117441

212

117601

400

117885

245

118451

1000

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Tuesday, August 23, 2011 8:29:17 AM

Page 6

Work Order ID: 72981

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,185.000

4



Nut



4

Location

Loc Qty

Loc Code

ST300

1185

116105

5

116548

53

117441

498

117591

43

117611

90

118179

496

4

MS24665-151

Purchased

No

100

Each

430.0000

3



Cotter Pin



3

Location

Loc Qty

Loc Code

ST309

430

17566

430

3

MS24665-300

Purchased

No

100

Each

254.0000

2



Cotter Pin



2

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

54

116823

54

2

Tuesday, August 23, 2011 8:29:17 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, August 23, 2011 8:29:17 AM

Page 7

Work Order ID: 72981

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P Purchased  
Washer

No

100

Each

264.0000

6

Location

Loc Qty

Loc Code

ST275

264

117291

8

118179

56

118612

200

NAS1149C0432R Purchased  
Washer

No

100

Each

4,636.000

2

Location

Loc Qty

Loc Code

ST297

4636

116900

18

117291

4618

NAS1149F0332P Purchased  
WASHER

No

100

Each

216.0000

8

Location

Loc Qty

Loc Code

ST275

216

117735

87

118354

126

17317

3

NAS1149F0563P Purchased  
Washer

No

100

Each

192.0000

4

Location

Loc Qty

Loc Code

ST297

192

117735

192

Tuesday, August 23, 2011 8:29:17 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

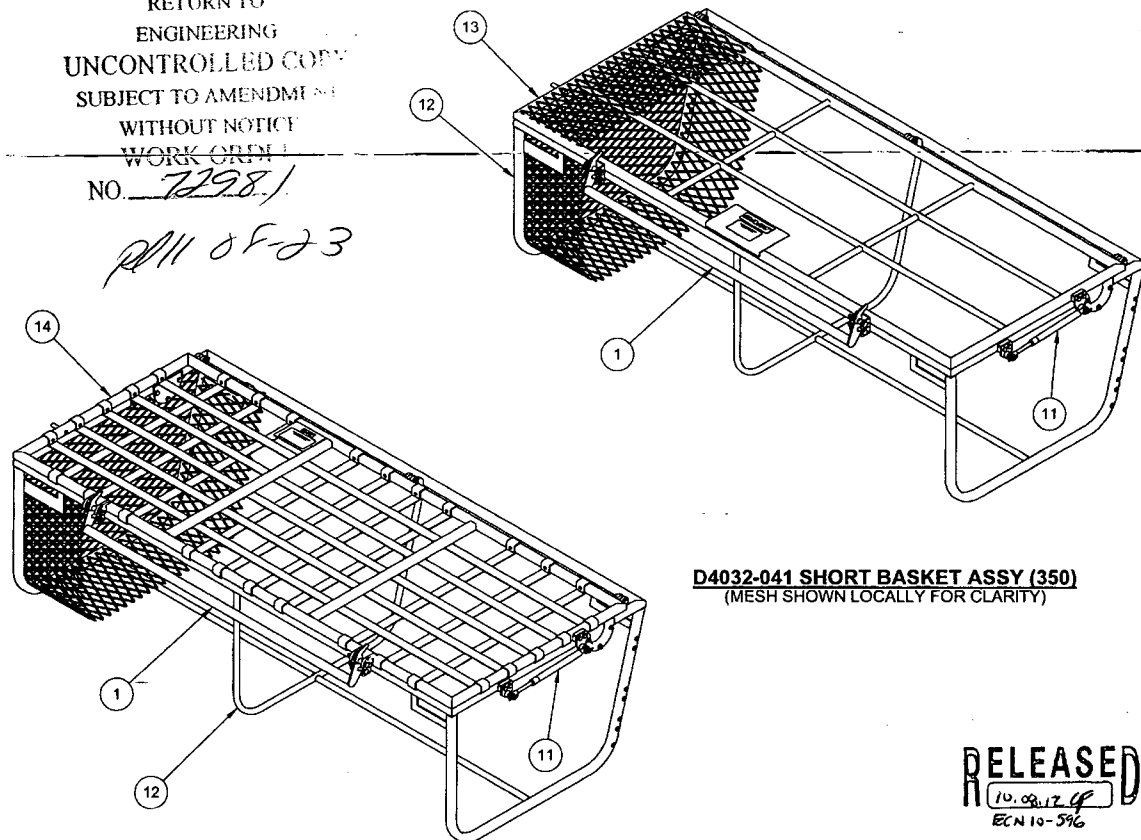
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 72981  
*PH 8F-23*



**D4032-041 SHORT BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

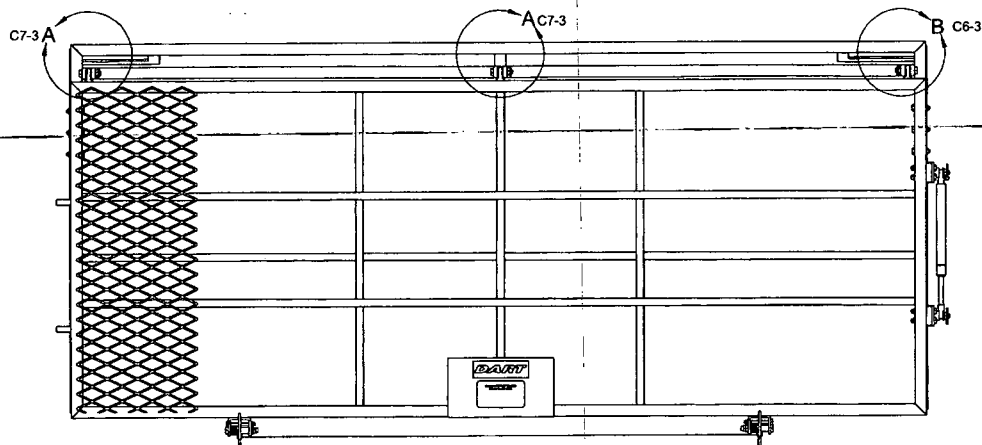
RELEASED  
10.07.23  
ECN 10-596

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER

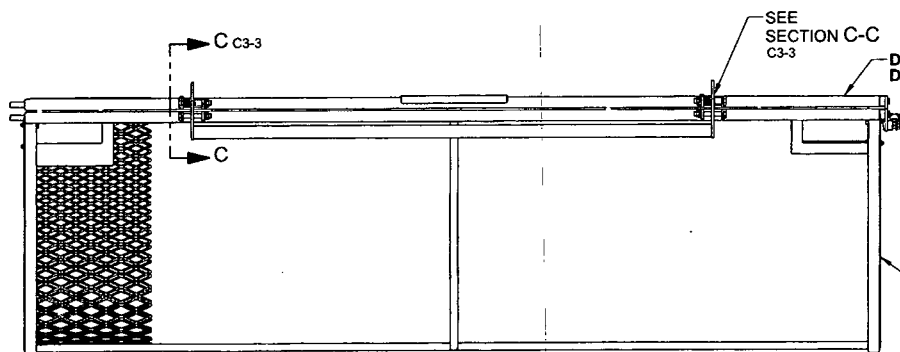
NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: -041: 56 lbs APPROX  
              -043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED, ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JES	DRAWING NO.	REV. D
MFG. APPR.	JES	D4032	SHEET 1 OF 2
APPROVED	WJD	TITLE	SCALE
DE APPR.	JES	SHORT BASKET ASSY (350)	—NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



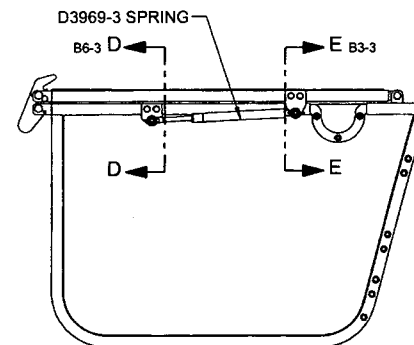
D2530  
HANDLE WELDMENT



SEE  
SECTION C-C  
C3-3

D4032-041: D4018-041 LID ASSY  
D4032-043: D4019-041 LIGHT LID ASSY

D4017-041  
SHORT BASKET BASE ASSY



**D4032-041 SHORT BASKET ASSY (350) (SHOWN)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

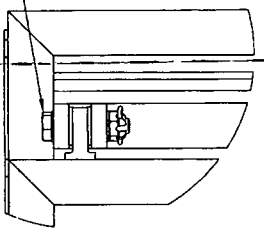
RELEASED  
10.08.17

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4032</b>	REV. D
MFG. APPR.	JFS		SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SHORT BASKET ASSY (350)</b>	NTS
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8 7 6 5 4 3 2 1

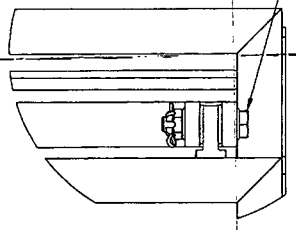
72987

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



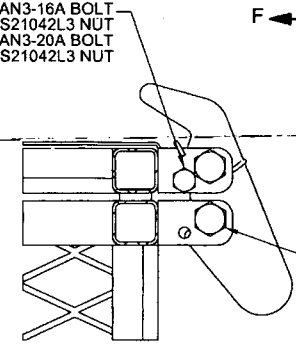
**DETAIL A** D8-2  
D6-2

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



**DETAIL B** D4-2

D4032-041: AN3-16A BOLT  
MS21042L3 NUT  
D4032-043: AN3-20A BOLT  
MS21042L3 NUT

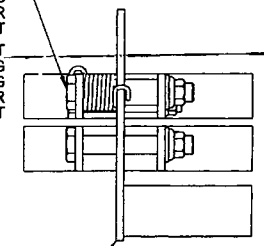


**SECTION C-C** B5-2  
B7-2

D4032-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D4032-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

AN5-17A BOLT  
NAS1149F0563P WASHER  
MS21042L5 NUT



D2530 WELDMENT  
REF

**VIEW F-F** C3-3

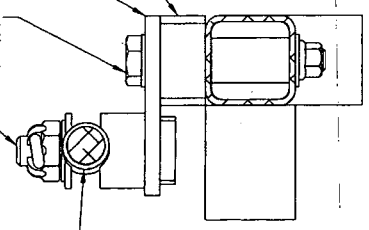
D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-2



D3953-17 GAS SPRING SPACER

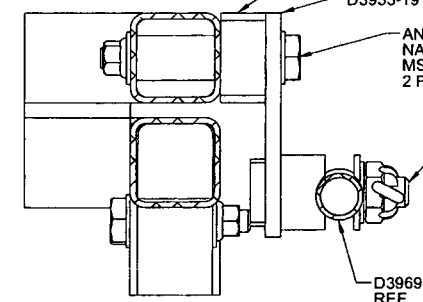
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2



**RELEASED**  
10.08.17.0

DESIGN	AUS	<b>DART AEROSPACE LTD</b>	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4032</b>	REV. D
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